Rev E 1/14/01/24

Work Order ID 111331 *111331*

January-13-14 10:49:22 AM

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Aft, Center Ceiling Panel **Stop** *NS2*

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-01-13 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4634 Revision Nbr: PD2 ~~PET~~ Rev E DAS 27 9-89 per ECN 14-5709									
100	HAND FINISHING THERMOFORMING	0.00							
100 Thermoform	**Memo** Cut Blanks	0.00				x1	____	____	DL 14/01/12
Thermoforming Machine									
105	Dry Material	0.00							
105 HandThermo	**Memo** Dry Sheet as per QSI022 POLYCARBONATE	0.00				x1	____	____	DL 14/01/12
Hand Finishing Thermoforming	Temp: 275° F Time IN: 5:00 am 14/01/11 Time OUT: 6:00 am 14/01/12								

Work Order ID 111331

January-13-14 10:49:22 AM

111331

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft, Center Ceiling Panel

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					X1			14/01/13
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-5 and Folio FTA146								
	Dwg. Rev. E								
	Folio Rev. B								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					X1			14/01/21
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						X1			14/01/21
QC	**Memo**	0.00							
Quality Control									

Item ID: D4634-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft, Center Ceiling Panel
Start Date: 1/13/14 **Start Qty:** 1.00 *1*
Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1			
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Packaging					MLS			
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS 27 9-88 14/1/22

Thermoforming

Hyfed as Rev Dwn PEJ

MLS 14-01-23

POSITIVE RECALL EFFECTIVE 14/01/22 WITH DATE 14/01/24

MF 14-1-23

DAS 27 9-89 14/1/23

Release Dwg Rev E

Picklist Print

January-13-14 10:49:25 AM

Work Order ID: 111331 *1113331*

Parent Item: D4634-5 *D4634-5*

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 1/13/14 **Required Date:** 1/27/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	12.93	16			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

16 sq ft.

14/01/23

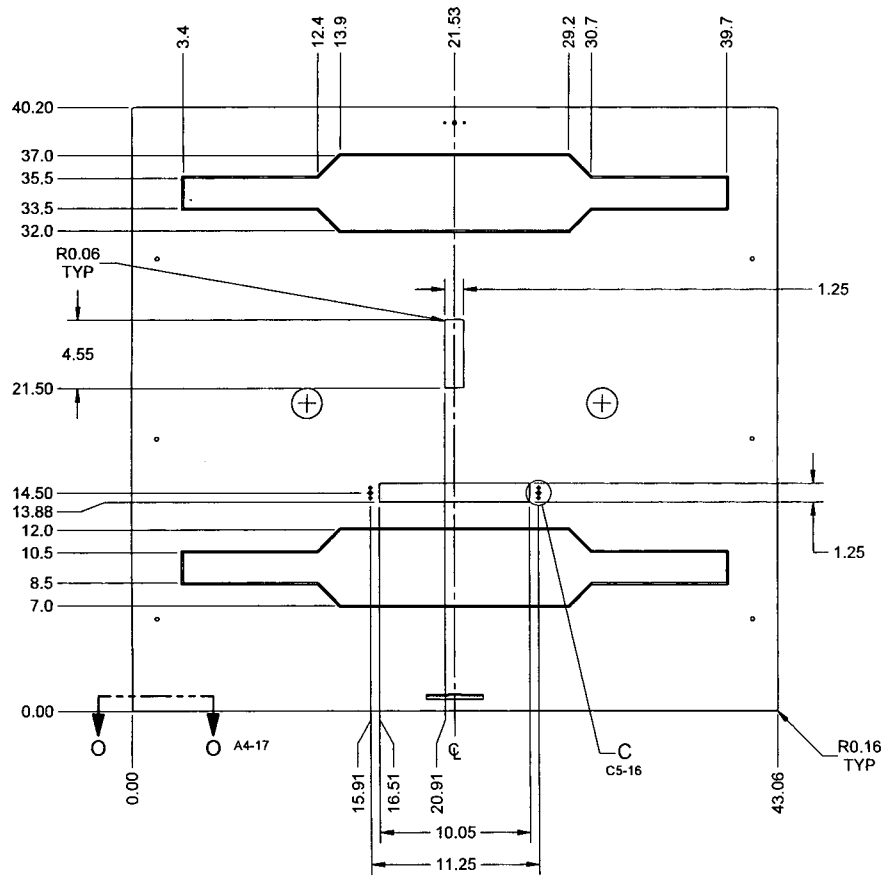
DART AEROSPACE LTD

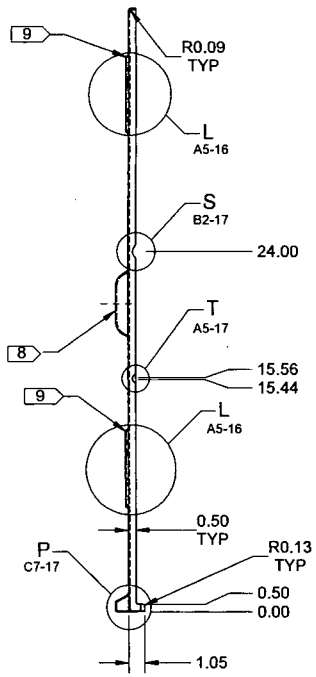
Description:	PANEL	Work Order:	11331
Inspection Drawing:	D4634	Rev: PE1	Part Number: D4634-5

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.50"	+/-0.030	14.50"	✓		TAPE DL-01	
11.25"	+/-0.030	11.25"	✓		"	
10.05"	+/-0.030	10.05"	✓		"	
21.50"	+/-0.030	21.50"	✓		"	
4.55"	+/-0.030	4.53"	✓		Vern DL-02	
20.50"	+/-0.030	20.50"	✓		TAPE DL-01	
11.66"	+/-0.030	11.66"	✓		"	
31.40"	+/-0.030	31.40"	✓		"	
39.18"	+/-0.030	39.18"	✓		"	
1.30"	+/-0.030.	1.31"	✓		Vern DL-02	
Ø 2.03"		2.02"	✓		Vern DL-02	
Ø 0.250"		0.250"	✓		"	
0.63"	+/-0.030	0.63"	✓		"	
3.80"	+/-0.030	3.77"	✓		"	

Measured by:	Checked By: WAS 27 9-89	QC inspector:	Engineering Approval (*if necessary*):
Date 14/01/21	Date 14/1/22	Date	Date

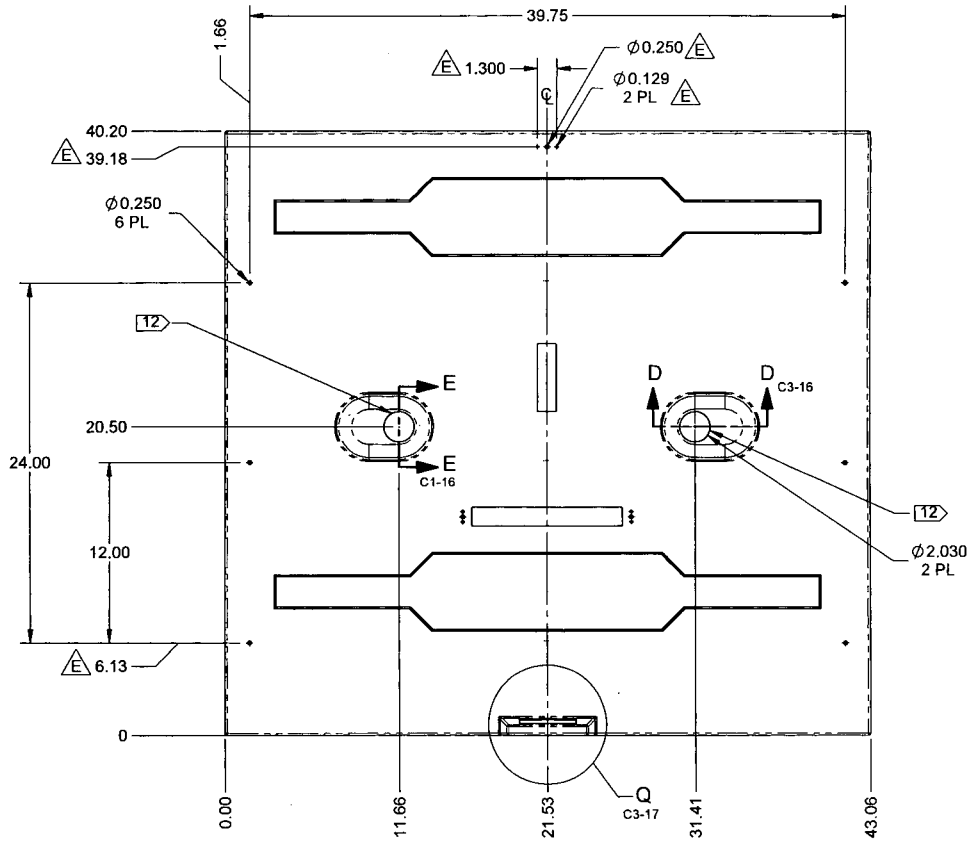




NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ∅2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

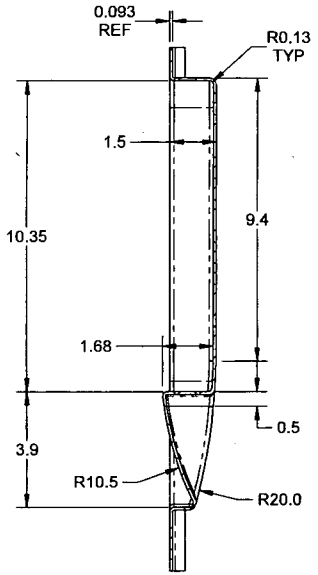
D4634-5 AFT, CENTER CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO. D4634	REV. PE1
MFG. APPR.			SHEET 14 OF 17
APPROVED		TITLE CENTER CEILING PANELS	SCALE NTS
DE APPR.			
DATE 14.01.09		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

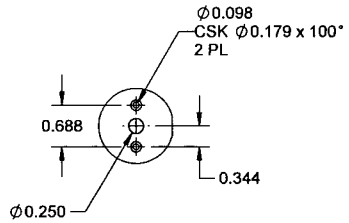


D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

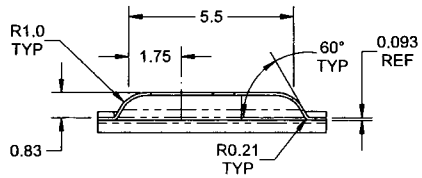
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 15 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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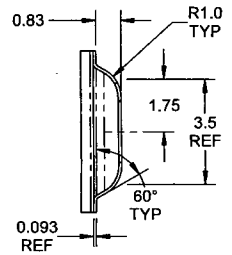
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SCALE 4X



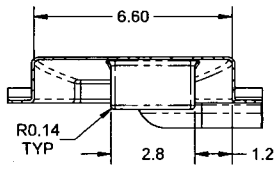
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SCALE 4X



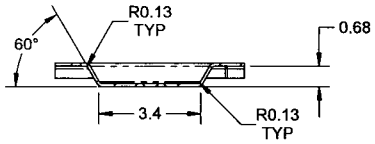
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SCALE 2X



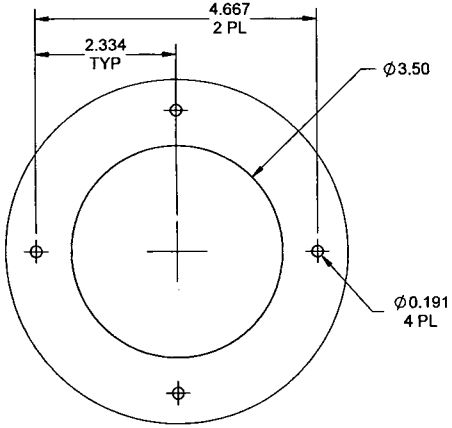
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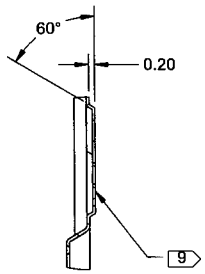
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SECTION J-J B6-13
SCALE 2X



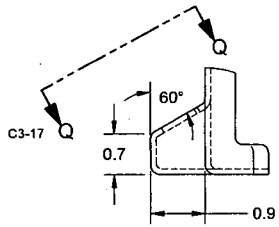
(E) **DETAIL B** B7-10
SCALE 4X
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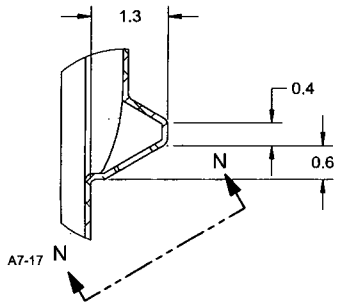
DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 16 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

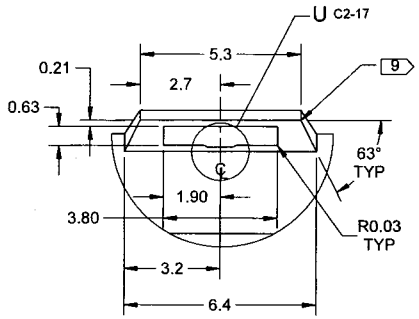
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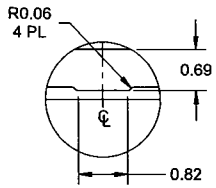
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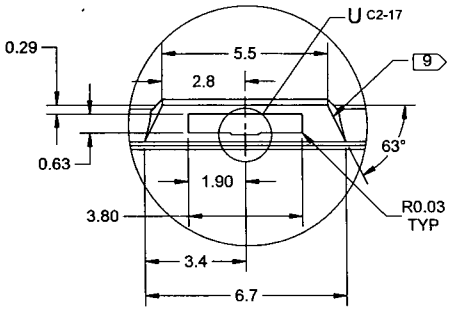
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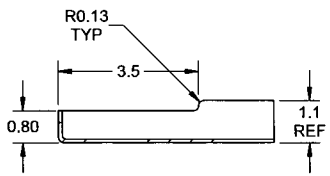
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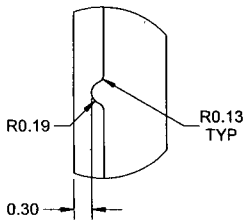
DETAIL U B7-17 D3-17
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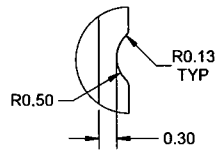
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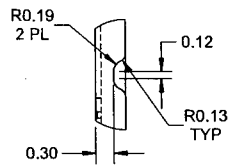
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



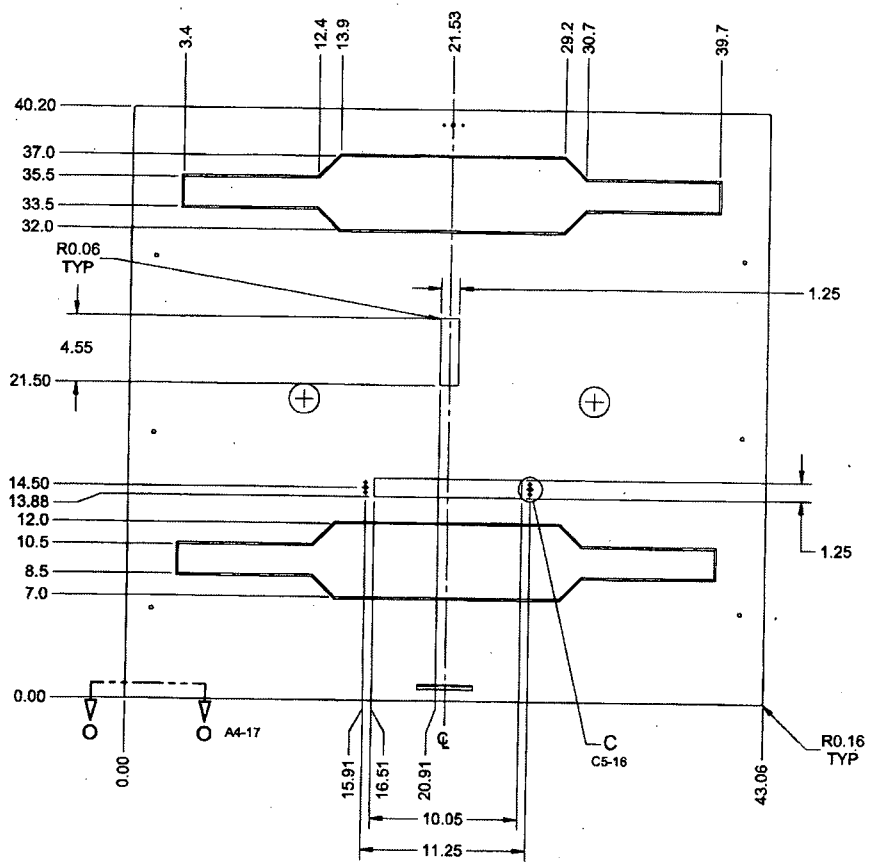
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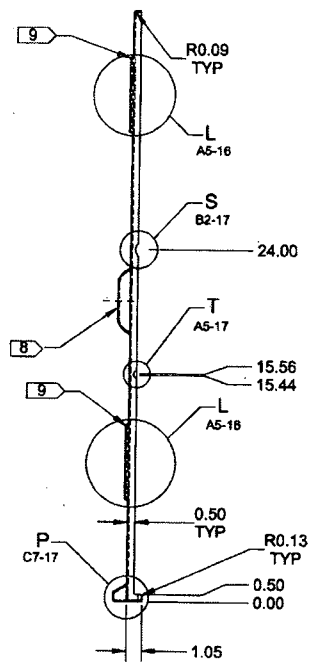


DETAIL T C2-14
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4634 REV. PE1
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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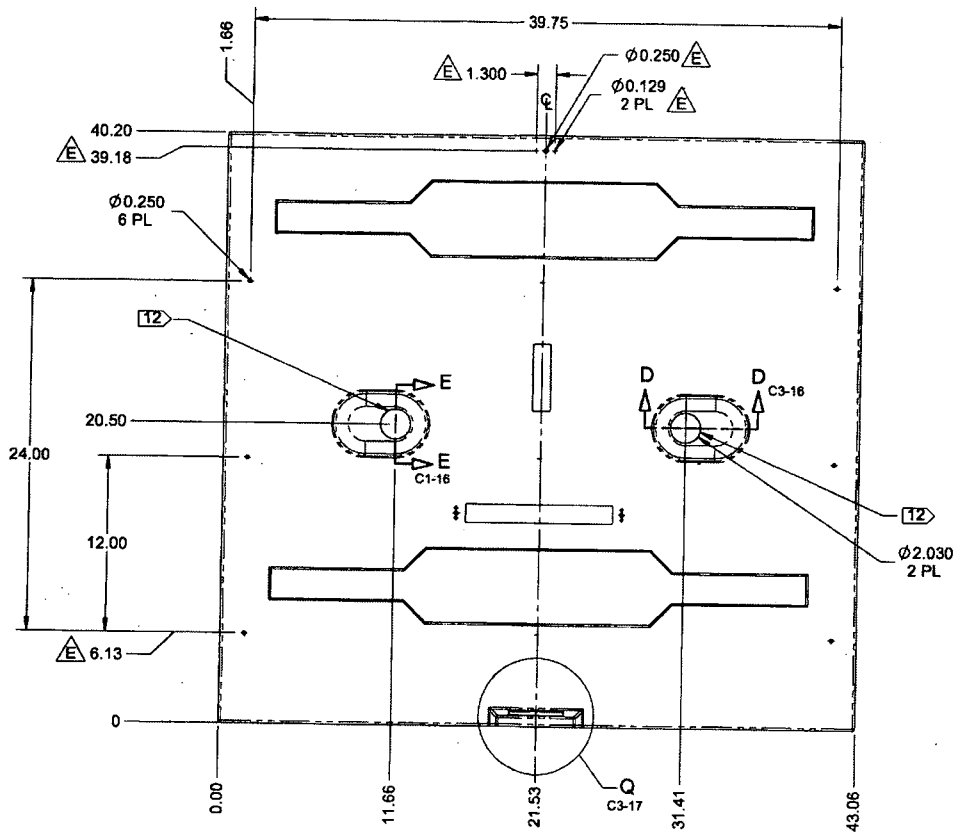


NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 7.39 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-5 PER TOOL DT9838
11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE Ø2.039 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT. CENTER CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. REV. E
MFG. APPR.		D4634 SHEET 14 OF 17
APPROVED		TITLE SCALE
DE APPR.		CENTER CEILING PANELS NTS
DATE	14.01.09	

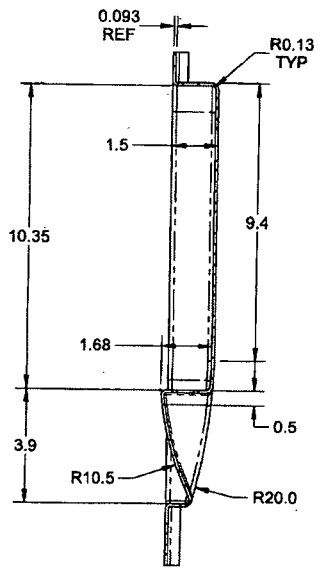
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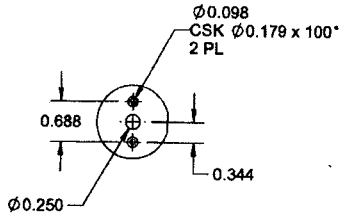
D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D4634	SHEET 15 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

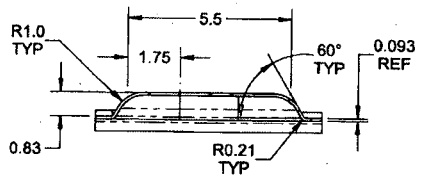
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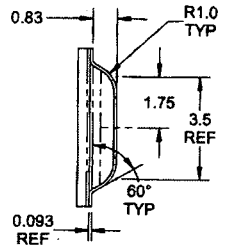
SECTION G-G C5-11
SCALE 4X



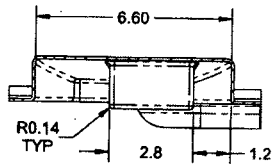
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



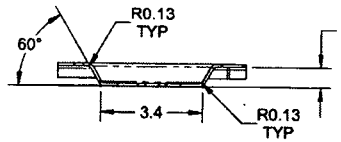
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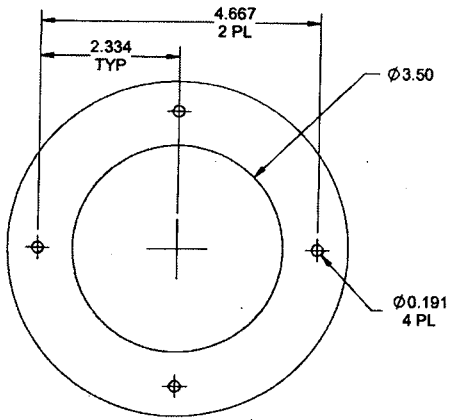
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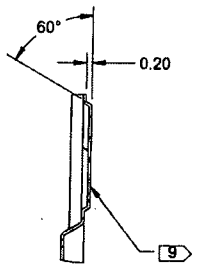
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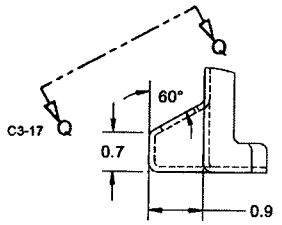
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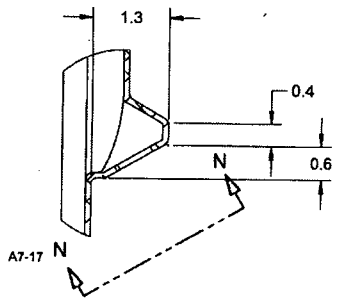
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APPROVED		TITLE	SCALE
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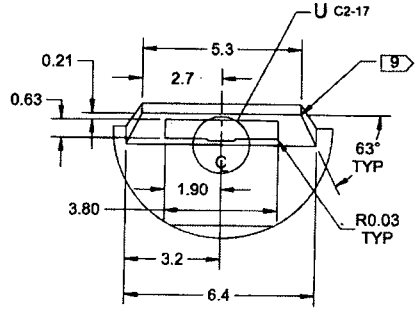
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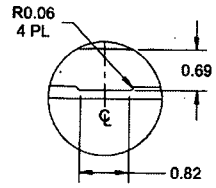
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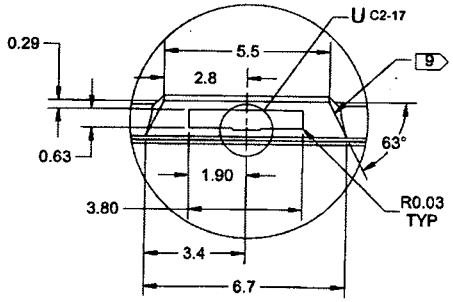
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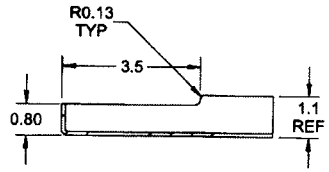
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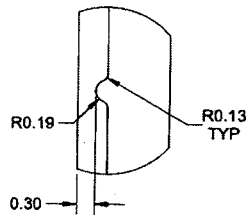
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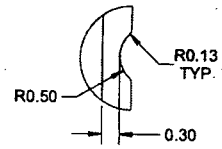
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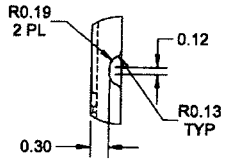
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DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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